

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006448**Date Inspected:** 30-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wen Pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG cross beam CB1

This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB2

This QA noted that this crossbeam has been set into the superstructure assembly. No significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB3

This QA received ZPMC Non Destructive Testing (NDT) notification No. 002868 and performed Ultrasonic Testing (UT) of approximately 10% of the welds previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated a UT report for this date. The weld designations are as follows: CB205E-001-009, 011, 008, 002, 004 and 006, CB205F-001-001, 005, 009, 010, 002 and 006.

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This QA observed ZPMC personnel thermally cutting the trim stock material off of the south end of this crossbeam.

OBG cross beam CB4

This QA observed ZPMC personnel perform clean up and grinding. No other significant work was observed on this cross beam during the time QA was present.

OBG cross beam CB5

This QA observed ZPMC qualified welding personnel identified as 037705 perform FCAW welding on weld joint identified as CB202G-005-027 and 028. ZPMC QC CWI identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2133.

This QA observed ZPMC qualified welding personnel identified as 204338 perform FCAW welding on weld joint identified as CB202A-001-008. ZPMC QC CWI identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 066480 perform SMAW welding on weld joint identified as CB202G-005-145 ~ 163. ZPMC QC CWI identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

This QA observed ZPMC qualified welding personnel identified as 068091 perform SMAW welding on weld joint identified as CB202G-006-151 and 152. ZPMC QC CWI identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

This QA observed ZPMC qualified welding personnel identified as 057795 perform SMAW welding on weld joint identified as FB205-008-026. ZPMC QC CWI identified as Mr. Zhang Yaxu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2212-B-U2.

OBG cross beam CB6

This QA observed That ZPMC personnel are in the process of fitting and tack welding floorbeam diaphragm sections in this crossbeam.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
